



Date: Friday, 2/23/2007 8:32:01 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 30891		
Estimate Number	: 10860		
P.O. Number	: N/A	Part Number	: D30421
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: D3042 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: 	Due Date	: 3/10/2007 Qty: 40 Um: Each
Checked & Approved By	:  07.02.23		
Comment	: Est. C 01.11.08 Revised Step 5 SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 3165

~~Laser cut per Dwg D3042~~ GFI

Material: AISI 304/316 SS 0.063" thick

Material release note required

C/L 07/02/24

(40)

2.0

D30421F

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

CLAMP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

P/O 7/4/23

(40)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

P/O 04.24

(40)

counted

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr any rough edges

Bond as per dwg D3042

Deburr : tumble.

→ SAB 07/05/03

(40)

N/A made @ GFI

For 24
see P/O 7.0 →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:01 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30891

Part Number: D30421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8B

07/05/04

40

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble

N/A

PTO

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/04 40

9.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07/05/04

40

Job Completion



07-05-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070424	7.0	Have parts deburred & tumbled on step 5.0, on this W/O. Not a Perm. Change, we will soon make these parts here. <i>No today</i>				<i>[Signature]</i> 070424	<i>[Signature]</i> 070424

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

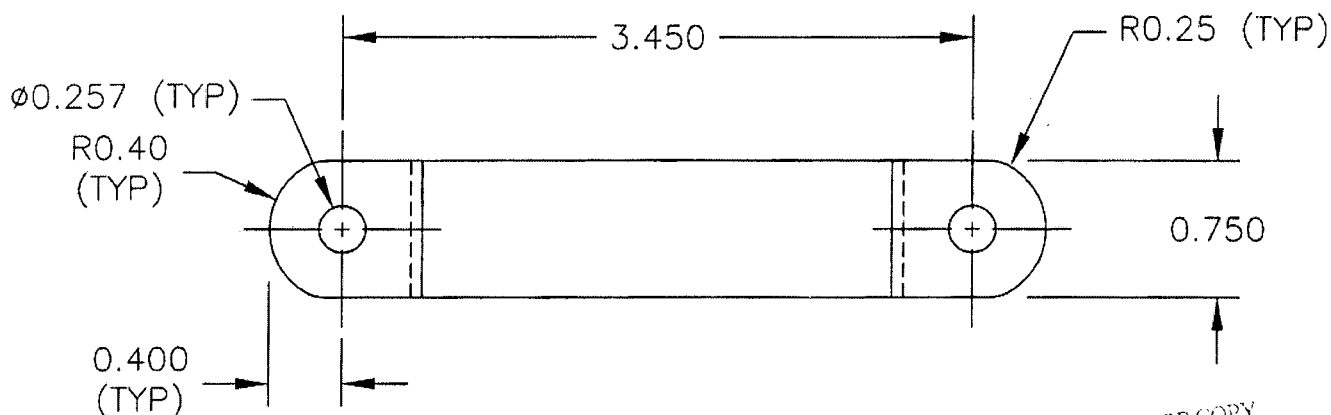
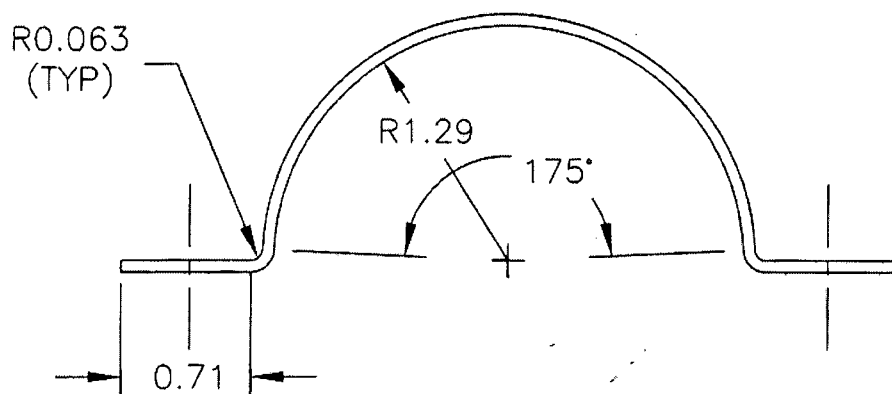
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3042	REV. A SHEET 1 OF 1
DATE 01.06.29		TITLE CLAMP	SCALE 1:1
A	01.06.29	NEW ISSUE	

RELEASED
01.07.09 *[Signature]*



D3042-1

- 1) MATERIAL: AISI 304/316 SS ANNEALED PER AMS 5513/5524
0.063 THICK
- 2) FLAT LENGTH: 5.713 END-TO-END
4.913 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUSCEPTIBLE TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30891

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180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2007/04/18	0362729

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE P.O. NO.	VIA SHIP VIA
DART GFI-0299		J0159868	PO00003165	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
40	D30421F	CLAMP CERTIFICATE OF CONFORMANCE REQ		

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY



Sigma Metals Inc.

45 Jefryn Blvd.

Deer Park, NY 11729

A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

180-07

Packing Slip

DATE 2/27/2007 INVOICE NO. 43030

BILL TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRE QUE, CANADA H9R 1A1

SHIP TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRE QUE, CANADA H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0070968	Net 30	MEC	YELLOW	DEER PARK, NY	59826

ITEM	DESCRIPTION	QTY
SS SHEET	304 STAINLESS STEEL SHEET ANNEALED AMS 5513 .063" X 48" X 36" 189 LBS. MILL: ATI LOT# 824074 REPLACEMENT NCR 4680 BOXING CHARGE	6

BOXING

GFI INC.

LE MATERIEL RECU NE SERA ACCEPTE
QU'APRES VERIFICATION DE DIMENSIONS
D'EPaisseur, POIDS ET CONDITIONS

SIGNATURE

[Signature]

DATE 01 MAR 07

CERTIFICATE OF COMPLIANCE

THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT
STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A
FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT
ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT
DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL
REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST
REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW.
THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED.

Gregory Saladino
Quality Control Manager

TEST REPORTS WITH SHIPMENT

FOR FEDEX, UPS, OVERSEAS AIR, AND AMERICAN EXPRESS

NOTICE OF SHIPMENT/
PACKING LIST



AL 5168A-7 400

CERTIFICATE OF TEST

SOLD TO		FORMS DISTRIBUTION		CUST. CODE		ACCEPTING MILL		SHIPPER NO.		PRODUCT CODE		MILL ORDER NUMBER		DATE SHIPPED			
				08/18/06		110977		NEW CASTLE, IN.		524046		13020102060000		30-096-051		12/12/06	
				REPEAT ORDER		DO RATE		PHI. ORITY		MATL		SHIPPING LOCATION		INVOICE			
				82037-4		26				1124		NEW CASTLE		IN		072704	
				PRIME SEC.													
				DSO		DSO											
				584													

GRADE AND SPECIFICATIONS
 ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

CARRIER - BOHREN LOGISTICS, INC.

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001	1	48./062/2129.	824074	11066N273	7732493	21585	60	21525		150974		
IF POSSIBLE SHIP WITH LOAD 4111 TO DEL 12/12												
C CUST IDENTITY 00640												
1 SKID												
						21585	60	21525				

TYPE	HEAT/TEST	--C--	--MN--	--P--	--S--	--SI--	--CR--	--NI--	--MO--	--CU--	--N--
HEAT	824074	.021	1.29	.034	.001	.35	18.28	8.03	.40	.45	.05

ITEM	TEST NO	YIELD	TENSILE	% ELONG	HARDNESS	BEND	A 262	PR E	SIZE
001	7732493	PSI *	PSI	IN 2" % R/A	83.HRB	T PASS	PASS	8.	
		T 47400.	92500.	58.	82.HRB				
* Y.S. BY 0.2% OFFSET METHOD									

ITEM	TEST NO	MELT	P&W
001	7732493	SOURCE	TRAN BEND
		1.	2.

REVIEWED BY Q.C.

Date 12/18/06 by CC

METALLOGRAPHIC MAGNIFICATION: 100X ETCHANT USED: OXALIC ACID

GRADE VERIFICATION WAS CARRIED OUT SPECTROSCOPICALLY

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE: Please Note - This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-6577. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires, veuillez téléphoner au numéro suivant 724-226-6577. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgment.

C. M. Napoli - Manager, Technical Information

12/12/06 10:17:44

CM Napoli

NOTICE OF SHIPMENT/
PACKING LIST



AL 6168A-7 400

CERTIFICATE OF TEST

CUST. CODE		ACCEPTING MILL		SHIPPER NO.		PRODUCT CODE		MILL ORDER NUMBER		DATE SHIPPED	
08/18/06		NEW CASTLE, IN.		524046		13020102060000		30-096-051		12/12/06	
FORMS DISTRIBUTION		REPEAT ORDER		DO RATE		MATERIAL		SHIPPING LOCATION		INVOICE	
SHIP TO		82037-4		26		1124 NEW CASTLE		IN		072704	
SOLD TO		PRIME		SEC.							
		DSO		DSO							
		584									

GRADE AND SPECIFICATIONS

CARRIER - BOHREN LOGISTICS, INC.
ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

AUSTENITIC STAINLESS STEELS ARE SOLUTION ANNEALED AT 1900 DEGREES FAHRENHEIT MINIMUM (1038 C) AND RAPIDLY COOLED TO DEVELOP THE SPECIFIED PROPERTIES. EVIDENCE OF CONFORMANCE IS PROVIDED BY THE ABILITY OF THE MATERIAL TO MEET THESE SPECIFIED MECHANICAL AND CORROSION REQUIREMENTS

ALLEGHENY LUDLUM DOES NOT USE MERCURY IN THE TESTING OR PRODUCTION OF ITS PRODUCTS. TO THE BEST OF ALLEGHENY LUDLUMS KNOWLEDGE, UNDERSTANDING, AND BELIEF, THIS MATERIAL WAS NOT CONTAMINATED BY MERCURY WHILE IT WAS BEING PRODUCED IN OUR FACILITIES.

NO WELDS/WELD REPAIRS PERFORMED.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:

1. - MATERIAL MELTED AND ROLLED IN THE UNITED STATES AND COMPLIES WITH DFARS EDITION 1998, SECTION 252.225-7014
2. - FOREIGN MELT AND ROLLED IN THE UNITED STATES

ALC HOLDS SEVERAL QUALITY AND LABORATORY CERTIFICATIONS THAT INCLUDE ISO-9001:2000, AS9100, AD 2000-MERKBLATT WO, AND EU PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, NADCAP MATERIALS TESTING, ISO/IEC17025, GEAE S400. REFER TO WWW.ALLEGHENYLUDLUM.COM TO ACCESS THE CURRENT ALC QUALITY CERTIFICATIONS.

ALLEGHENY LUDLUM / ALLEGHENY RODNEY WORKS TO THE ROLLS ROYCE RR9000:SABRE REQUIREMENTS.

PAGE 02 - CONTINUED ON PAGE 03

CONSIGNEE: Please Note-This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on receipt before signing.

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C. M. Napoli - Manager, Technical Information

12/12/06 10:17:44

CM Napoli

NOTICE OF SHIPMENT/
PACKING LIST



AL 6168A-7 400

CERTIFICATE OF TEST

CUST. CODE		ACCEPTING MILL		SHIPPER NO.		PRODUCT CODE		MILL ORDER NUMBER		DATE SHIPPED	
08/18/06		110977		NEW CASTLE, IN.		524046		13020102060000		30-096-051	
FORMS DISTRIBUTION		REPEAT ORDER		DO RATE		GOVT CONTRACT		MATERIAL		INVOICE	
SOLD TO		82037-4		26				1124 NEW CASTLE		072704	
SHIP TO		PRIME		SEC.				IN			
SPEC		DSO		DSO							
		584									

GRADE AND SPECIFICATIONS

CARRIER - BOHREN LOGISTICS, INC.
ALLEGHENY STAINLESS STEEL TYPE 304-L SHEET C R COILS ANNEALED 2B FIN 3 EDGE (FMI 304L/304/302 ISSUE 5) (AMS 2248E) (AMS 5511H) (AMS 5513H) (AMS 5516N) (ASTM-A-262-02A PRA E/SCREEN PRA A) (ASTM-A-666-03) (S-400 DTD 4/28/04) (ASTM-A-240-05A) (S-1000 DATED 1/3/05) (ASME-SA-240-A05) (01/04/05 EXCEPT FMI 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (F-14, F-17, F-22, F-23, F-MASTER) (PWA 300 REV BH) -- CONTROL TO P&WA REQUIREMENTS FOR LCS --

THIS CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL WITHOUT THE WRITTEN APPROVAL OF THE COMPANY. THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ALC QUALITY MANUAL REVISION 16 DATED 08/07/2006. ALC HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001. DIN EN 10204:2005 - 3.1. ALLEGHENY LUDLUM IS APPROVED AS A MANUFACTURER ACCORDING TO AD-MERK BLATT WO/TRD100 AND THE PRESSURE EQUIPMENT DIRECTIVE PED 97/23/EC. TESTING WAS PERFORMED AT ALC NADCAP AND ISO/IEC 17025 APPROVED LABORATORIES LOCATED AT NATRONA HEIGHTS, BRACKENRIDGE, LATROBE, MIDLAND AND LEECHBURG PA FACILITIES OR A NADCAP AND ISO/IEC 17025 ACCREDITED LABORATORY.

ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:

C, S BY COMBUSTION/INFRARED
N, O, H BY INERT FUSION/THERMAL CONDUCTIVITY
MN, P, SI, CR, NI, MO, CU, CB, CO, V BY WDXRF
B BY OES
AL AND TI (>=0.10%) BY WDXRF, OTHERWISE BY OES
PB, BI, AG BY GFAA

SIGMA METALS INC.

THESE TEST REPORTS APPLY TO:

GFI
P.O. 0070966
S/O 52828
PCS. FTG
NET 189# DATE 2.27.07

PAGE 03 - FINAL PAGE

ISSUED BY ALLEGHENY LUDLUM - 12/13/06 07:51
CAROLE DEFILIPPI / QUALITY ASSURANCE DEPT.

CONSIGNEE: Please Note—This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

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C. M. Napoli - Manager, Technical Information